

Order 11943



Dart Aerospace Ltd.
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Canada

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D3319-3 Job Sheet 188874



Part No: D3319-3

Job Qty: 19 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 1/31/19 Feb-21

Created By: Dara Macdonald

Type: Stock

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		1/31/19	0.00	1.40	Waterjet - Flow		De 19/02/25
110	QC	6 pcs		1/31/19	0.00	0.00	QC2 Waterjet-2		De 19/02/25
120	QC	6 pcs		1/31/19	0.00	0.00	QC8-2		SC 9/02/28
140	Brake NC	12 pcs		1/31/19	0.12	0.84	Brake NC 1		DAS 200 19/03/06
150	QC	12 pcs		1/31/19	0.00	0.00	QC5		SC 9 19/03/06
160	Autoweld 1	12 pcs		1/31/19	0.00	3.82	Automated welding		3-00 JPL
170	QC	12 pcs		1/31/19	0.00	0.00	QC10		EL
180	QC	12 pcs		1/31/19	0.00	0.00	QC5		EL
190	SprayPaint	12 pcs		1/31/19	0.00	1.20	Spray Paint		RD 19-3-9 DAS
200	QC	12 pcs		1/31/19	0.00	0.00	QC3		MAR 11 2019 40
210	Packaging	12 pcs		1/31/19	0.00	0.00	Packaging3-1 ST2603		SC MAR 12 2019 DAS 89
220	QC21-SA	12 Ea		1/31/19	0.00	0.00	QC21		MAR 13 2019 70

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 5147896

210 - Identify on inside surface using a permanent fine point marker with the following:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	19.5000 sf (3.25 ea)	100-Waterjet - Flow - 1	5152150 5152142

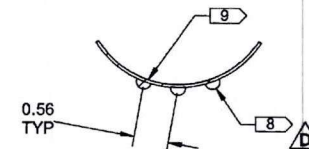
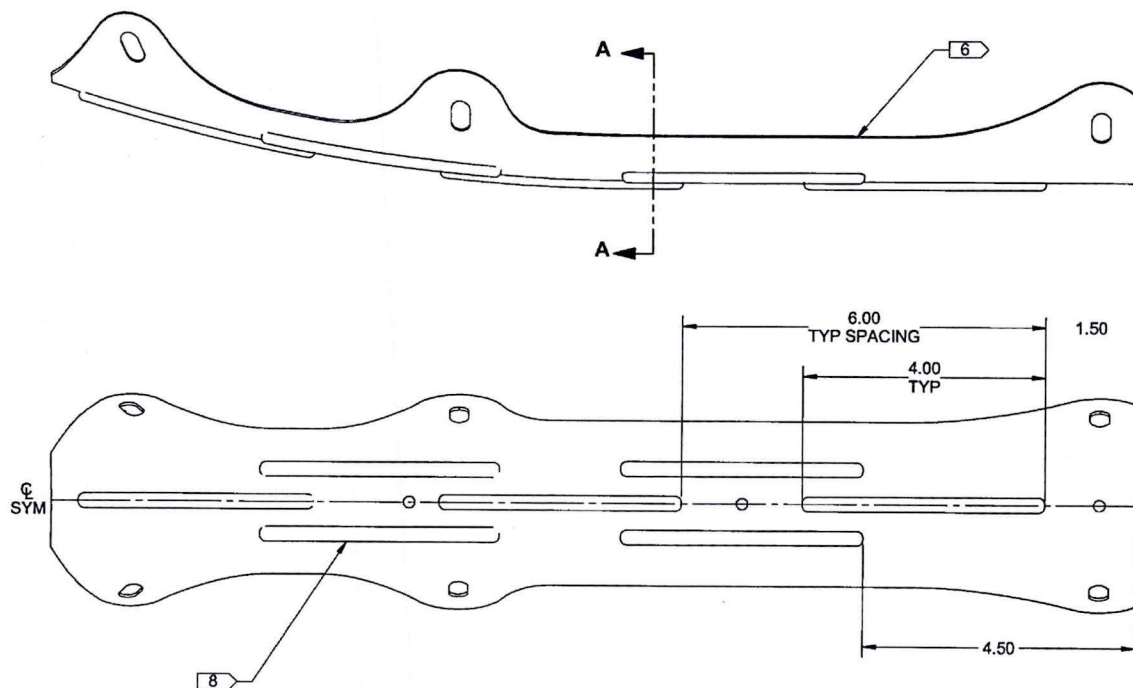
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	20	168	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499		
3	Wearplate	0.316inches ± 0.010	0.326 0.306		
4	Wearplate	0.607inches ± 0.010	0.617 0.597		
5	Wearplate	2.940inches ± 0.030	2.970 2.910		
6	Wearplate	2.690inches ± 0.030	2.720 2.660		
7	Wearplate	3.527inches ± 0.010	3.537 3.517		
8	Wearplate	4.520inches ± 0.030	4.550 4.490		
9	Wearplate	5.063inches ± 0.010	5.073 5.053		
10	Wearplate	6.160inches ± 0.030	6.190 6.130		
11	Wearplate	0.600inches ± 0.030	0.630 0.570		
12	Wearplate	8.690inches ± 0.010	8.700 8.680		
13	Wearplate	30.790inches ± 0.010	30.800 30.780		
14	Wearplate	52.880inches ± 0.030	52.910 52.850		
15	Wearplate	62.770inches ± 0.010	62.780 62.760		
16	Wearplate	74.420inches ± 0.010	74.430 74.410		
17	Wearplate	75.520inches ± 0.030	75.550 75.490		
18	Wearplate	0.050inches ± 0.010	0.060 0.040		

Plex 1/16/19 11:12 AM Dart.Macdonald.Dara



SECTION A-A

D3319-1 WEARPLATE
MAKE FROM D3319-1BND

RELEASED

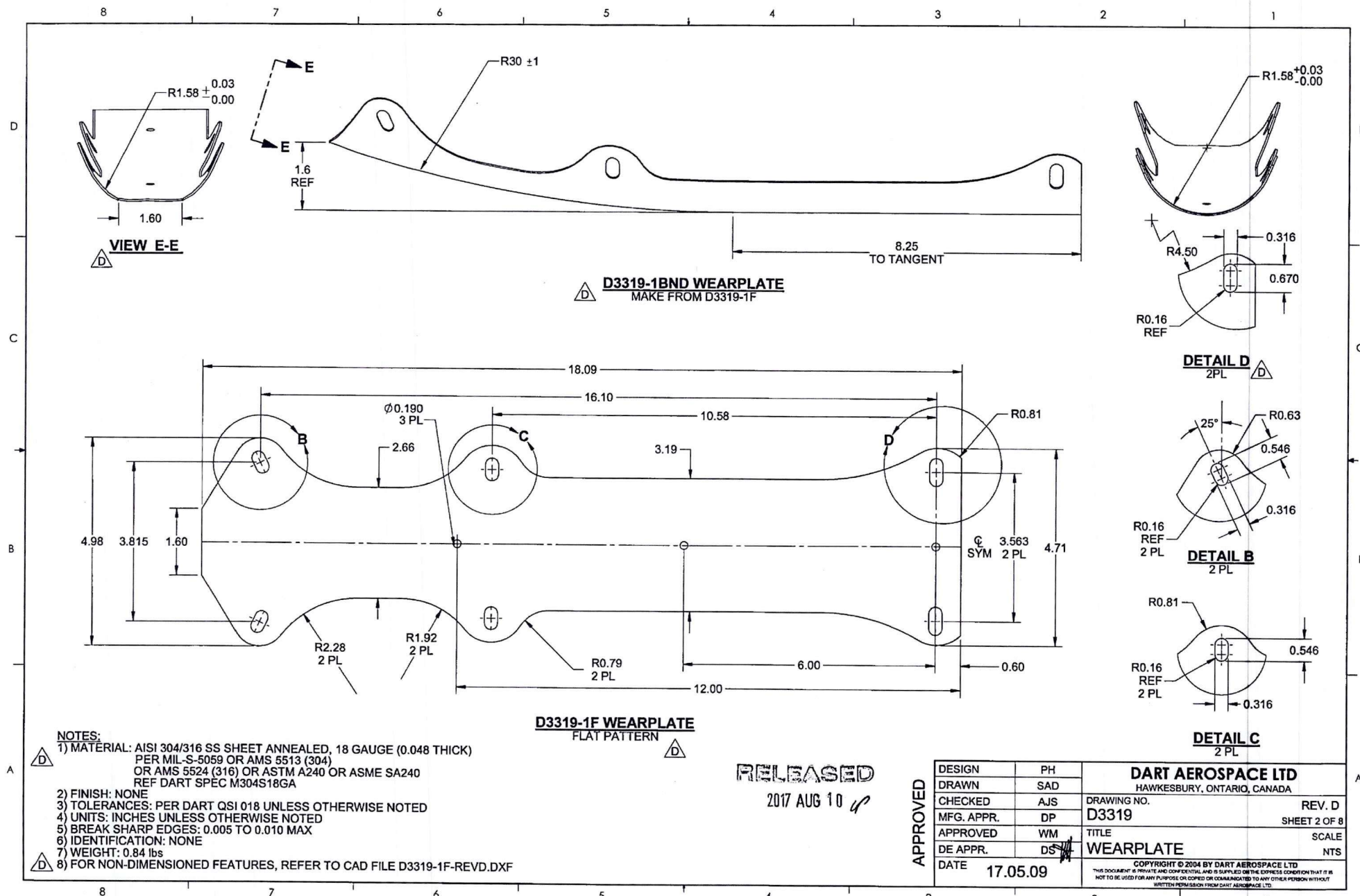
2017 AUG 10

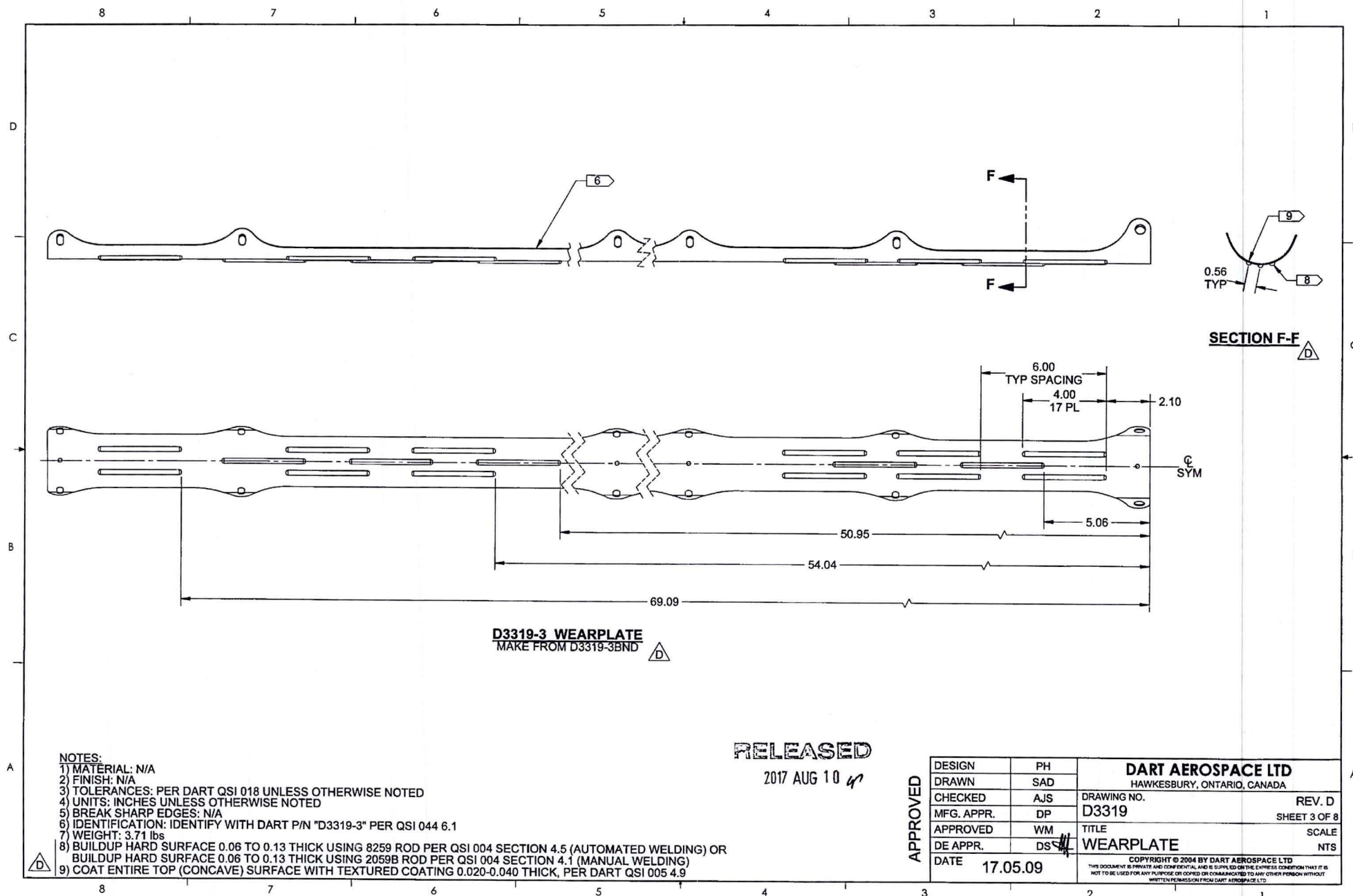
EN 17.44

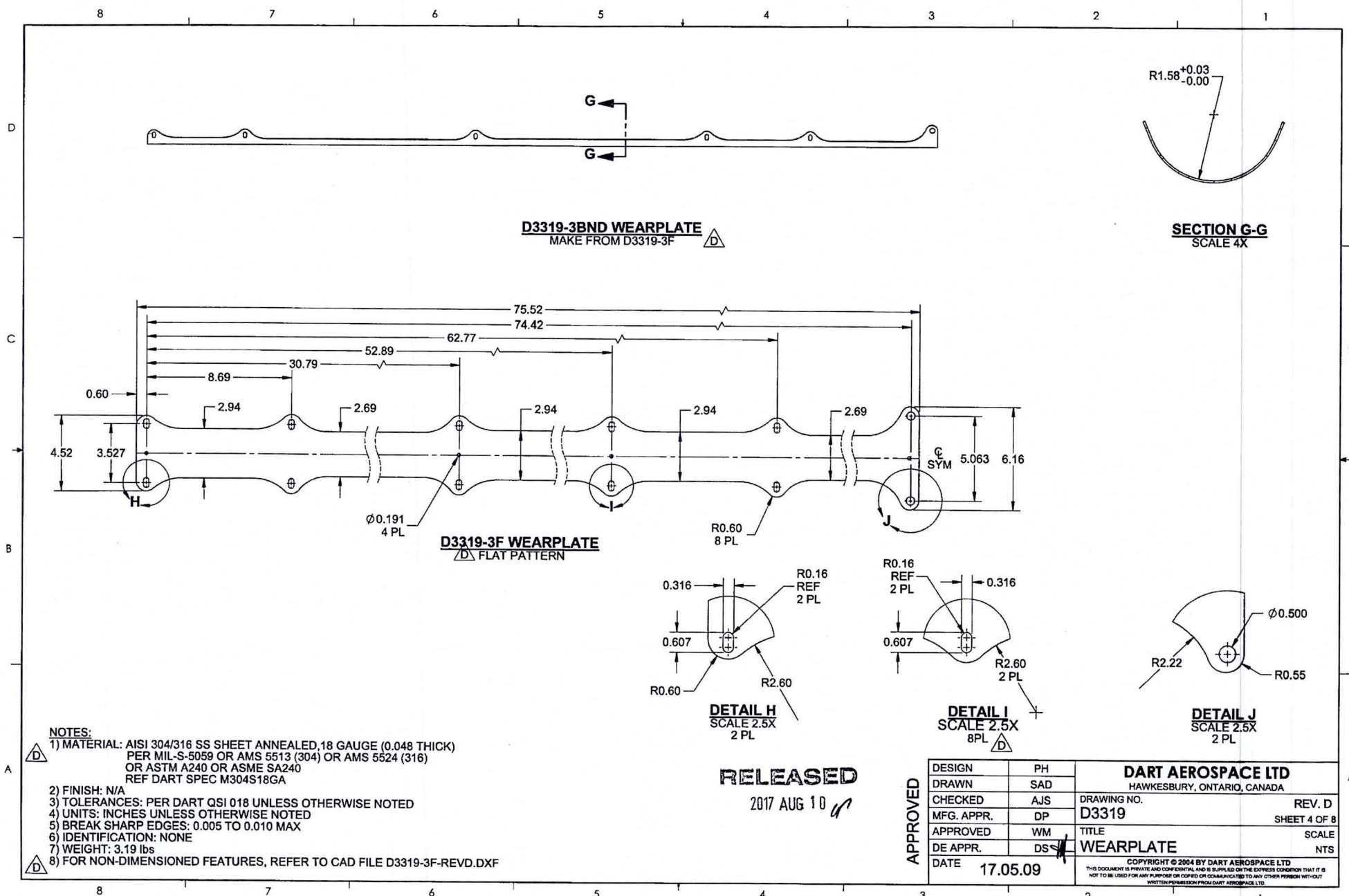
NOTES:

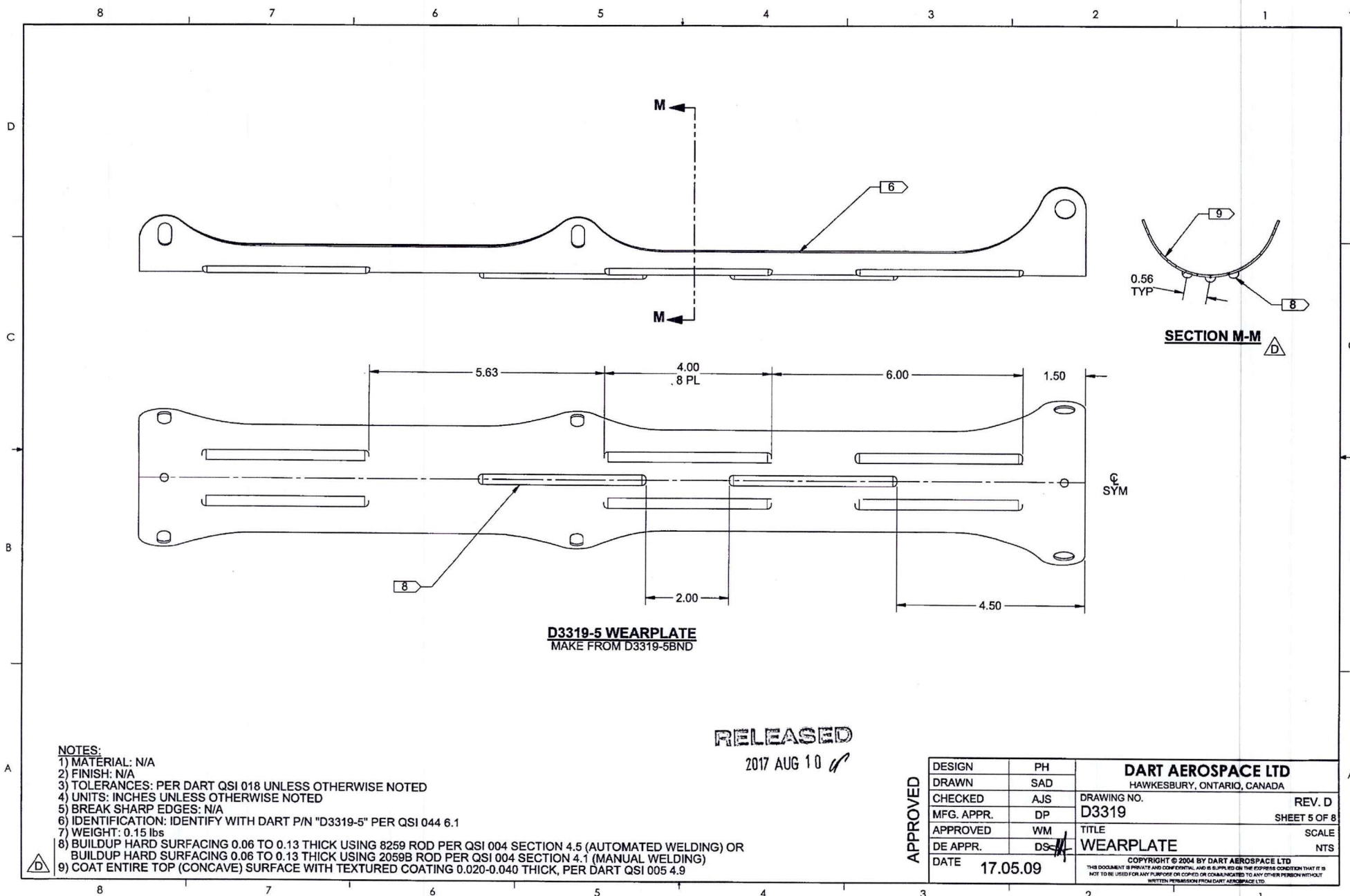
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-1" PER QSI 044 6.1
- 7) WEIGHT: 1.09 lbs
- 8) BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

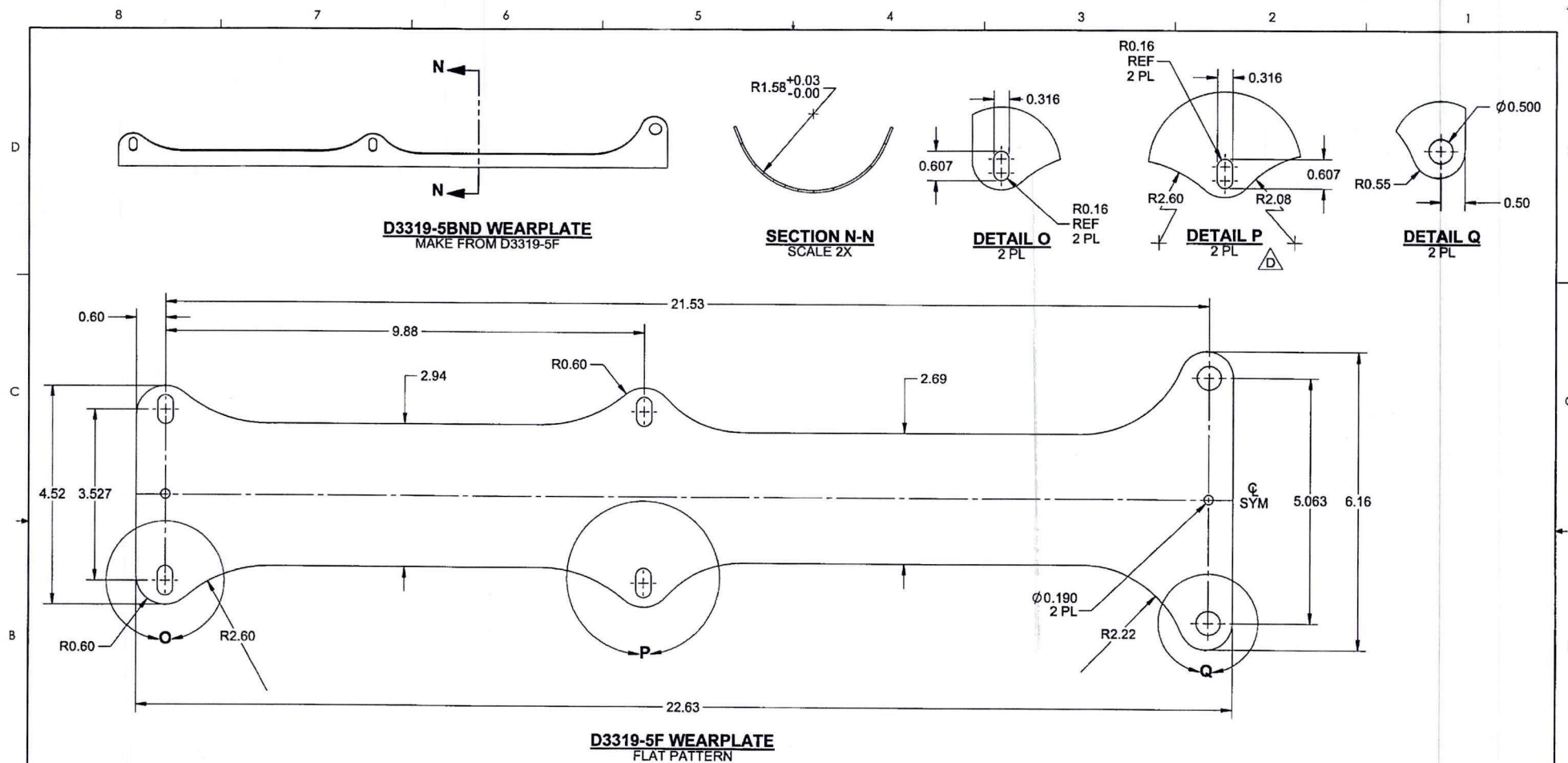
APPROVED	DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA D3319 WEARPLATE	
	DRAWN	SAD		
	CHECKED	AJS		
	MFG. APPR.	DP		
	APPROVED	WM		
	DE APPR.	DS	WEARPLATE SCALE NTS	
	DATE	17.05.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
REV.		DESCRIPTION	BY	DATE
D		REVISE DRAWING TO SOLIDWORKS FORMAT, UPDATE NOTES, ADD ROBOTIC WELDING PROCESS, UPDATE TOLERANCES TO REFLECT INSPECTION CAPABILITY, CHANGE DRAIN HOLE LOCATION D3319-1, 12.00 WAS 12.600 (IN B6-2), CHANGE WELD, PATTERN AND ADD MISSING DRAIN HOLES D3319-1-3, CHANGE MTL TO SS 304/316, ADDED D3319-XBND, SECTION VIEW F-F, AND UPDATED VIEW E-E ADDED DETAIL D, I, P	SAD	17.05.09
C		UPDATE TO CURRENT STANDARDS IAW QSI 043: CLOSED AFTMOST HOLE OF -3/51-7 (REF DETAIL G) SEE NCR 12-547	MB	12.03.13
B		WIDEN HOLES, REDUCE WIDTH OF -3/51-7	PH	05.06.06
A		NEW ISSUE	PH	04.09.24











NOTES:

1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 18 GAUGE (0.048 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR
ASTM A240 OR ASME SA240 18 GAUGE (0.048 THICK)
REF DART SPEC M304S18GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.15 lbs

8) FOR NON-DIMENSIONED FEATURES, REFER TO CAD FILE D3319-5F-REV.D.XF

9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

RELEASED

2017 AUG 10

APPROVED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DP	D3319	SHEET 6 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	17.05.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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Container No: S156581



Part: D3319-3

Job No: 188874

Serial No/Batch: S156581

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/26/19